

**ABSTRACT OF THE DISCLOSURE**

Methods and systems are provided for the continuous coating and fabrication of spiraled steel rebar product for concrete structures.

5     Specifically, methods and systems are provided by which linear uncoated rebar is supplied to a polymeric (preferably, epoxy) powder-coating unit whereby a substantially uniform coating layer of a polymeric material is applied onto the uncoated rebar to form a linear coated rebar; and thereafter the linear coated rebar is bent into a spiraled steel rebar

10    product. The bending unit employed to bend the linear coated rebar includes a series of bending wheels having separated upstream and downstream bending wheels and a central bending wheel which is disposed between and below these upstream and downstream bending wheels. By bringing the linear coated rebar into contact with the series of

15    bending wheels, the rebar may be bent gently into spiraled steel rebar product without damage to the polymeric surface coating. In this regard, it has been found that such gentle bending of the coated rebar may be advantageously accomplished using bending wheels which include a rubber-like tire mounted on a rigid rotatable wheel member.